

Work Order ID **76993****\*76993\***

Page 1

November-24-11 2:44:38 PM

Item ID: D3294-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Doubler  
Start Date: 24/11/2011 Start Qty: 20.00 **\*20\*** Cust Item ID:  
Required Date: 08/12/2011 Req'd Qty: 20.00 **\*20\*** Customer:  
Reference:  
Approvals: Process Plan: M.L.J Date: 11/11/24 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_  
Run Start **\*NR1\***  
Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3294	Sheet 5-6 rev.C	E 11.11.24							
100		0.00							
<b>*100*</b>									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3294								
2024.080	Dwg Rev: <u>E</u>								
	Prog Rev: <u>E</u>								
	****grain direction as per dwg D3294 ****								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*110*</b>									
QC	Memo	0.00							
Quality Control									

B11-12-12

(27)

B11-12-12

November-24-11 2:44:38 PM

Page 2

**Accept**

Setup Start \*NS1\*

Stop \*NS2\*

Stop \*NS2\*

\*20\*

**Cust Item ID:**

\*20\*

**Customer:**

Run Start \*NR1\*

Stop \*NR2\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

120	QC8- Inspect parts - second check	0.00	
-----	-----------------------------------	------	--

0.00

QC Memo 0.00 04/12/13 867

### Quality Control

130	0.00
-----	------

0.00

Brake NC	Memo	0.00	1	
----------	------	------	---	--

Brake NC 1- Deburr if necessary 12/21/26

2- Bend as per Dwg D3294

140	QC5- Inspect part completeness to step on W/O	0.00	W/O
-----	---	------	-----

0.00

QC **Memo** 0.00 5/26/16 10/ \_\_\_\_\_

## Quality Control

# Work Order ID 76993

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**\*76993\***

Page 3

Item ID: D3294-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Doubler  
Start Date: 24/11/2011 Start Qty: 20.00 **\*20\*** Cust Item ID:  
Required Date: 08/12/2011 Req'd Qty: 20.00 **\*20\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*150*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									
170	Identify as per dwg & Stock Location <u>6A</u>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									

27x M/L 12/01/26

27x d M/L 12/01/26  
count

mlhbf 27x

**Work Order ID 76993**

November-24-11 2:44:38 PM

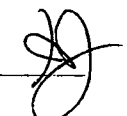
**\*76993\***

Page 4

Item ID: D3294-5 Accept **\*N9000040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Doubler  
Start Date: 24/11/2011 Start Qty: 20.00 **\*20\*** Cust Item ID:  
Required Date: 08/12/2011 Req'd Qty: 20.00 **\*20\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

12/1/30 

PL 12-01-27.  
(27)

# Picklist Print

November-24-11 2:44:42 PM

Page 1

Work Order ID: 76993

\*76993\*

Parent Item: D3294-5

\*D3294-5\*

Parent Item Name: Doubler

Start Date: 24/11/2011

Required Date: 08/12/2011

Start Qty: 20.00

Required Qty: 20.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S:080

Purchased

No

100

sf

204.3000

0.065

1.368421

2

\*\*

B11-12-12

\*M2024T3S 080\*

2024-T3 .080 sheet

### Location

### Loc Qty

### Loc Code

MAT022

204.3

105411

6

109424

4

110347

0.5

112331

3

113796

7

114025

15.7

116604

5.8

117392

40.1

118180

49.7

119117

72.5

117392

27

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	76993
<b>Description:</b> Doubler		<b>Part Number:</b>	D3294-5
<b>Inspection Dwg:</b> D3294 <b>Rev:</b> C		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

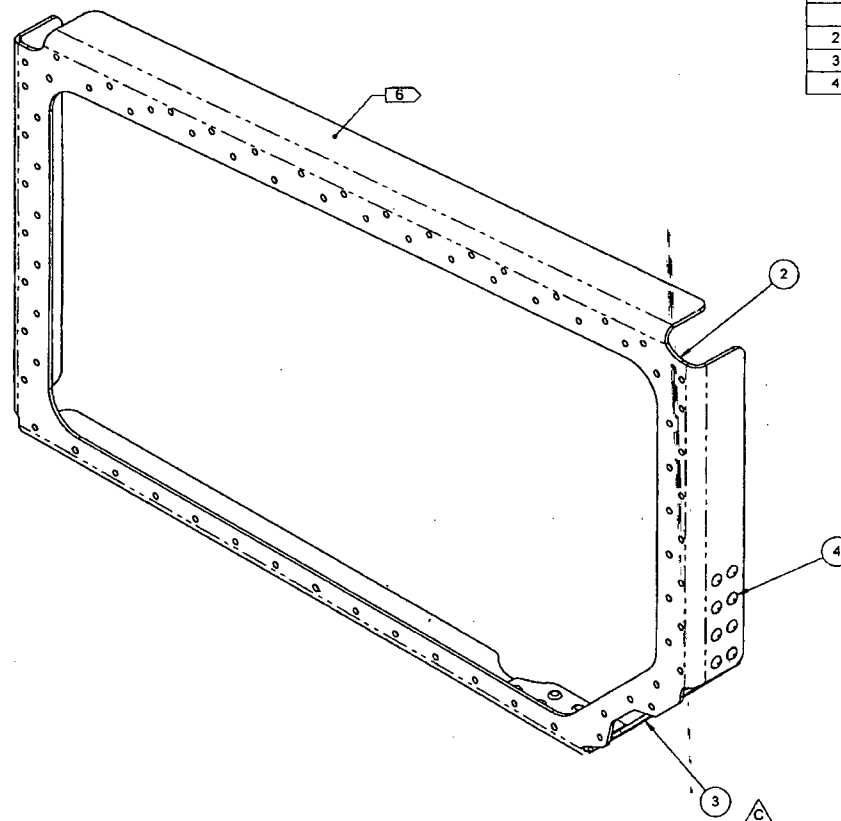
☒ **First Article**
         
 ☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.130	✓		V, 130Z	
0.65	+/-0.030	.653	✓		V	
0.30	+/-0.030	.301	✓		V	
0.53	+/-0.030	.53	✓		V	
3.36	+/-0.030	3.368	✓		V	
2.50	+/-0.030	2.494	✓		V	
0.15	+/-0.030	.151	✓		V	
9.21	+/-0.030	9.217	✓		PROW SOL	
0.400	+/-0.010	.401	✓		V	
0.300	+/-0.010	.300	✓		V	
0.30	+/-0.030	.303	✓		V	
0.625	+/-0.010	.626	✓		V	
0.080	+/-0.010	.081	✓		V	
1.00	+/-0.030	1.007	✓		V	

<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-12-17	<b>Date:</b> 11/12/17	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.07.29	New Issue	KJ	

ITEM NO.	QTY. -1	PART NUMBER	DESCRIPTION
1	X	D3294-1	BRACKET ASSEMBLY
2	1	D3294-3	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET



**D3294-1 BRACKET ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO - 76993 M.C.J

11/11/25

**RELEASED**  
09/03/24

C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6.	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE. ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.24		

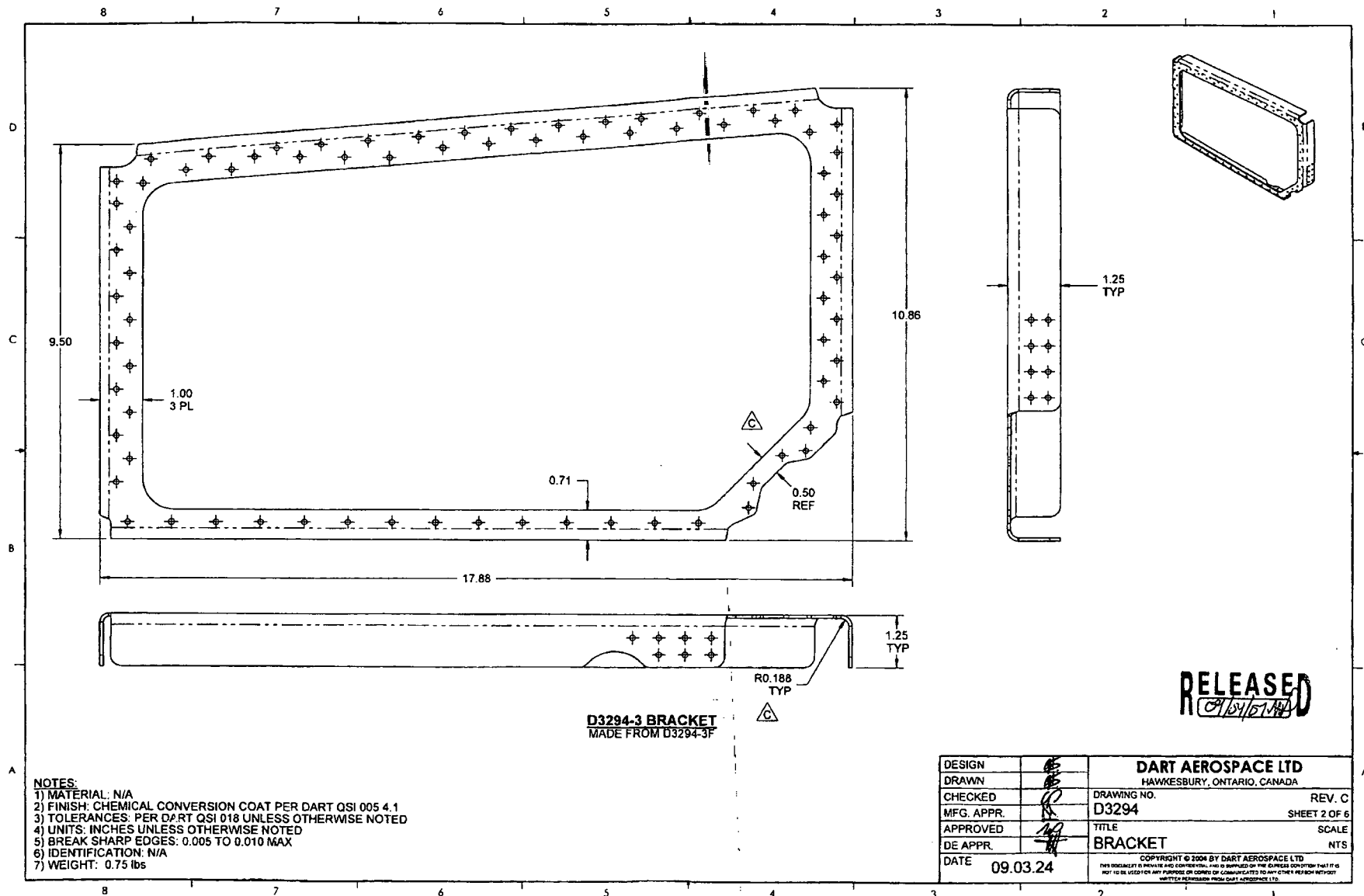
**DART AEROSPACE LTD**  
HA'WKESBURY, ONTARIO, CANADA

DRAWING NO. D3294 REV. C  
SHEET 1 OF 6

TITLE BRACKET SCALE NTS

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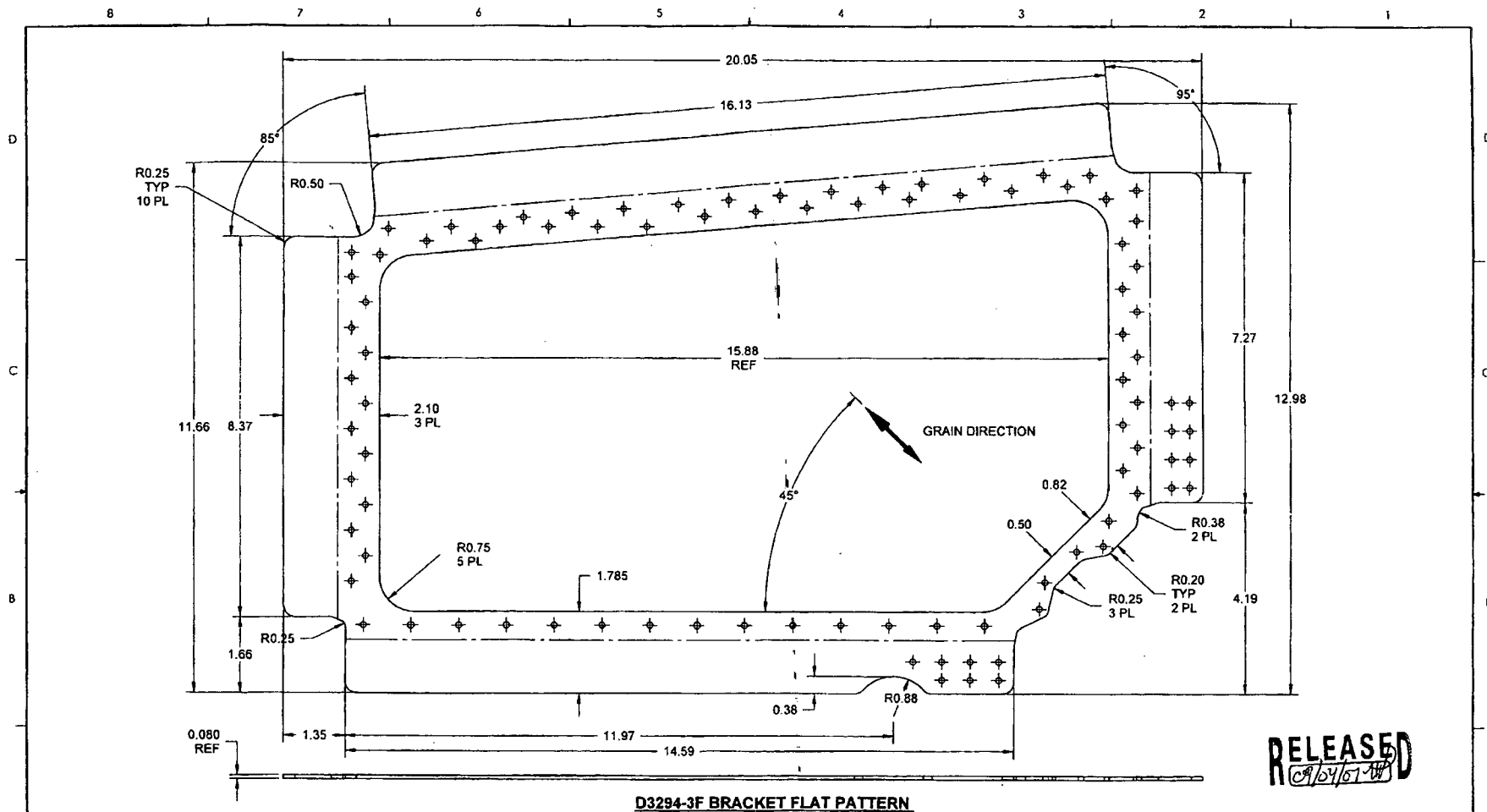
76993



RELEASED  
09/04/07



76993



RELEASED  
09/04/07

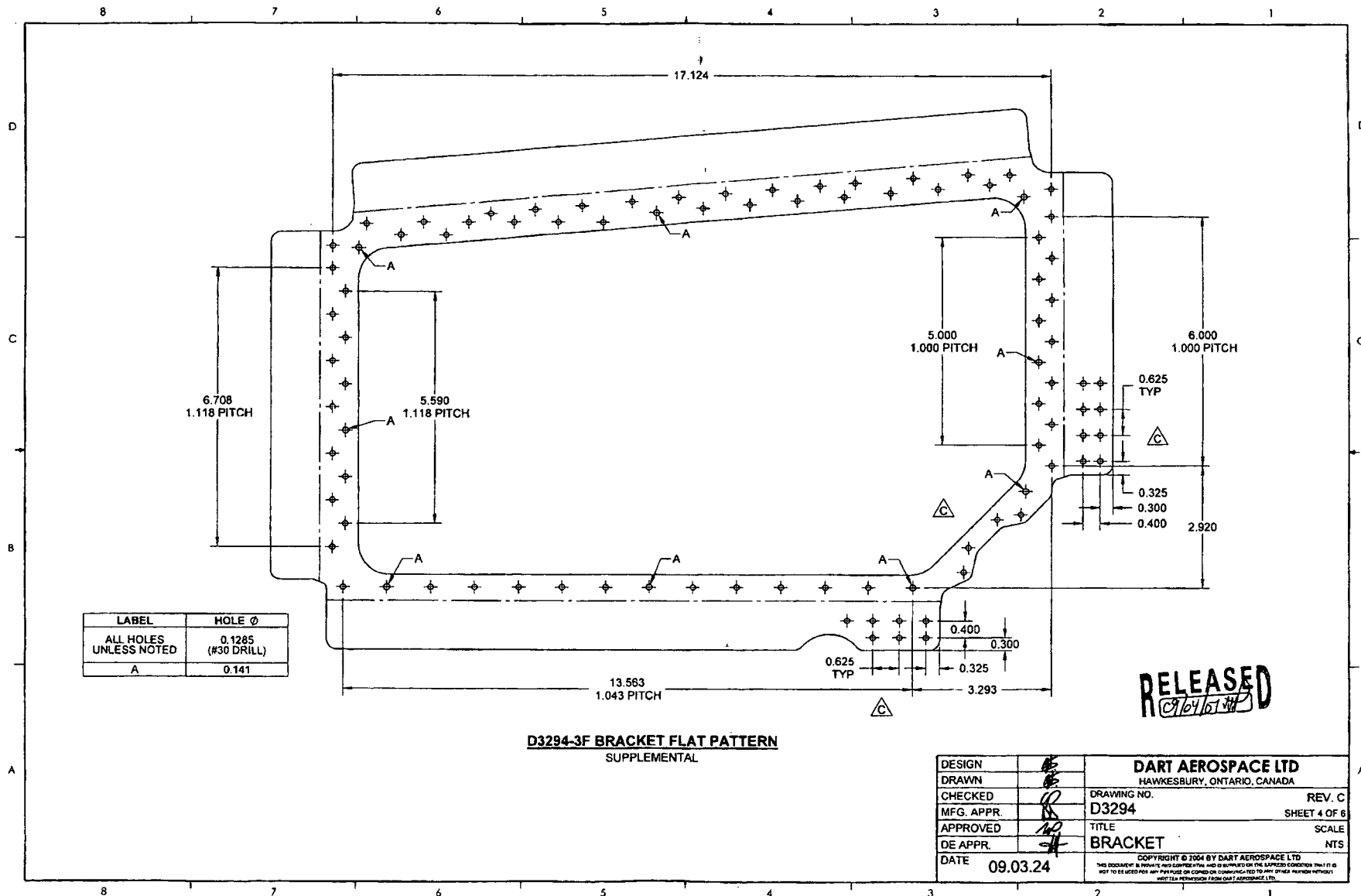
D3294-3F BRACKET FLAT PATTERN

NOTES:

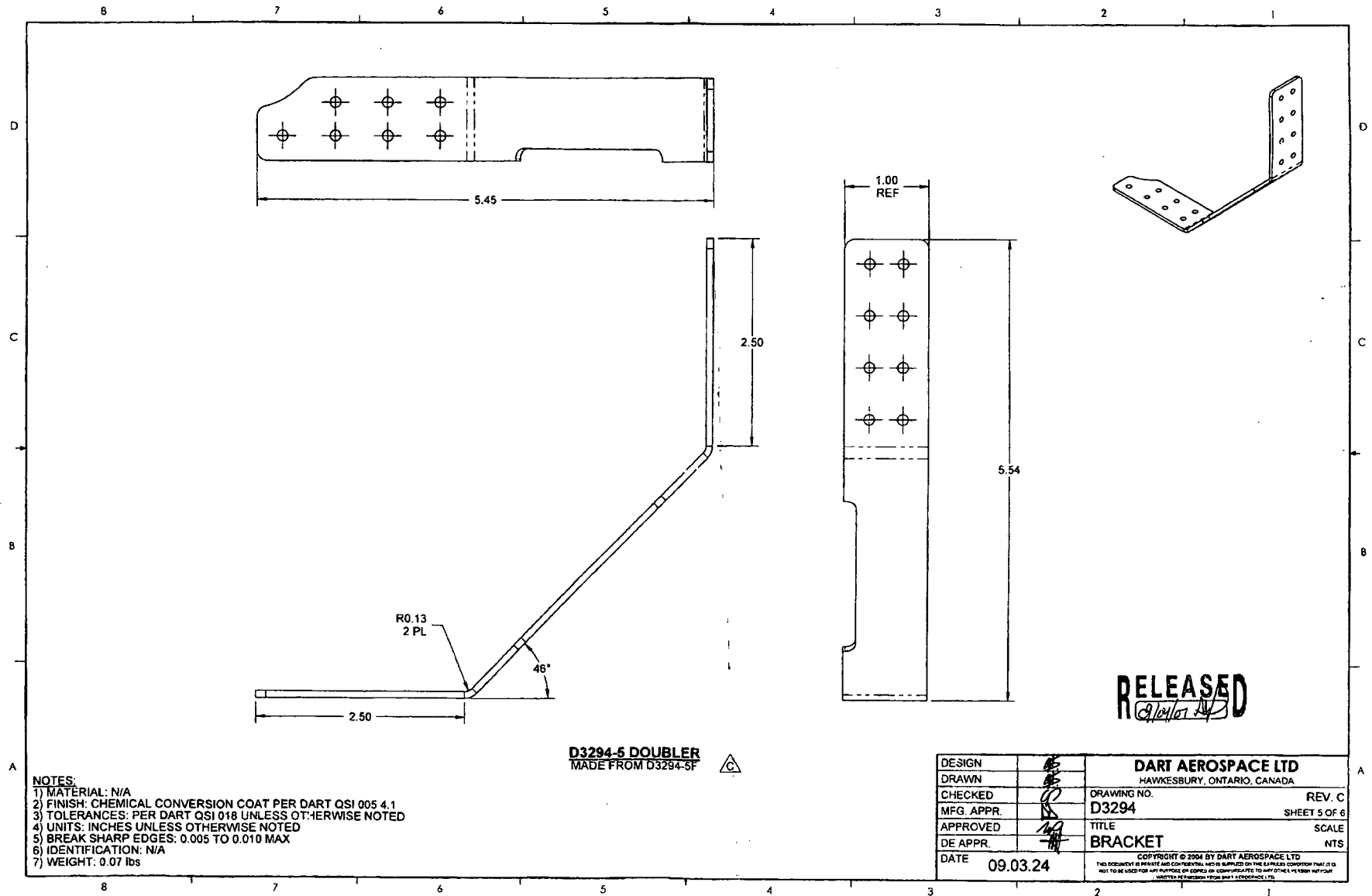
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3294	REV. C
MFG. APPR.		TITLE	SHEET 3 OF 6
APPROVED		BRACKET	SCALE
OE APPR.			NTS
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710993



76993



**D3294-5 DOUBLER**  
MADE FROM D3294-5F

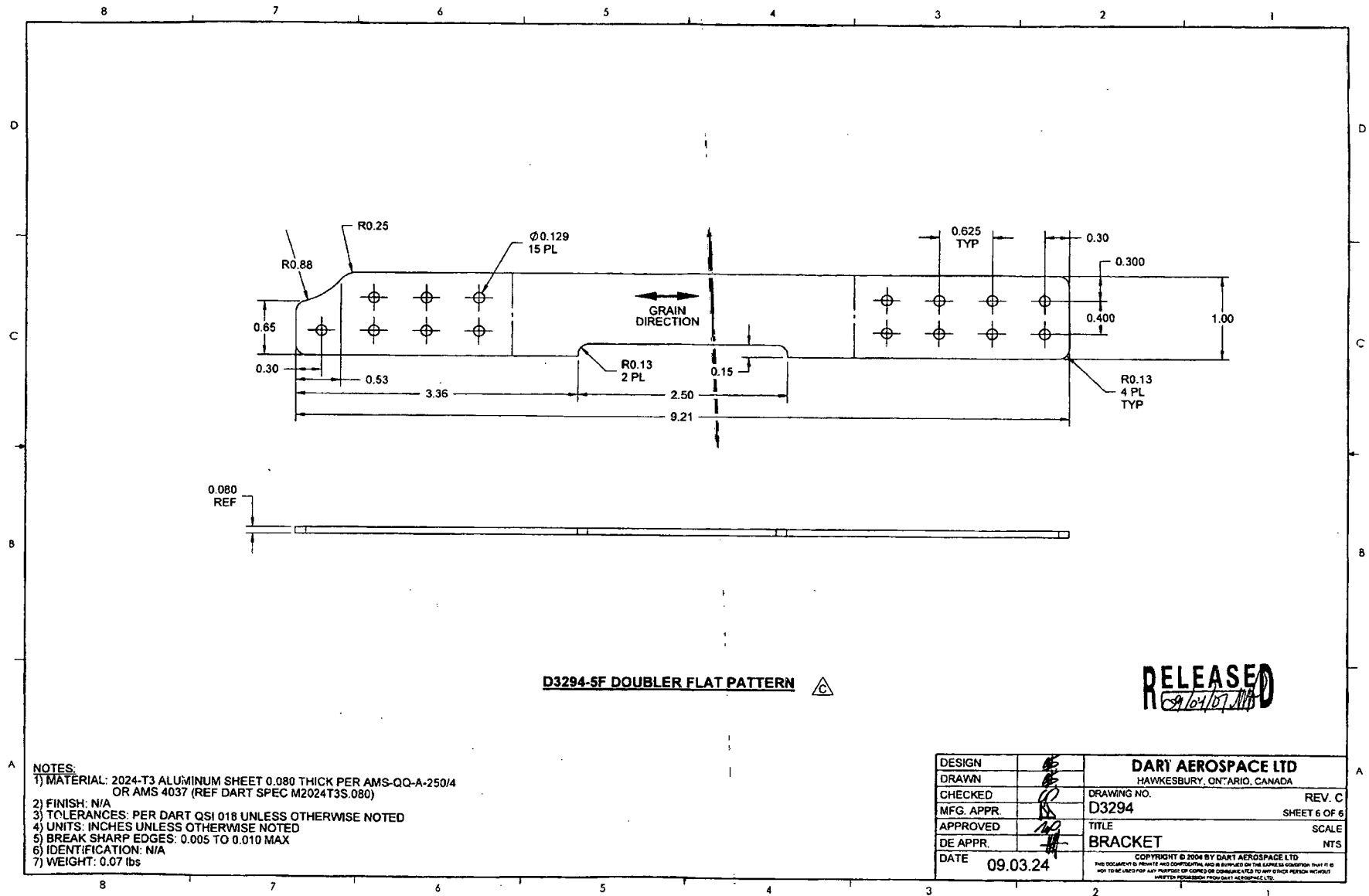


**RELEASED**  
9/14/01

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.07 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3294</b>	REV. C
MFG. APPR.		SHEET 5 OF 6	
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
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





76993



**D3294-5F DOUBLER FLAT PATTERN** 

**RELEASED**  
 29/04/07 

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.07 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3294</b>	REV. C
MFG. APPR.		SHEET 6 OF 6	
APPROVED		TITLE	SCALE
DE APPR.		<b>BRACKET</b>	NTS
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## Receiving Report

Date: 11/4/13 Batch No: 1117392  
 Supplier: THYSSERAND Dart P/O: 13762

Packing Slip: Yes ☒ No ☐ Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Invoice: Yes ☐ No ☒ Waybill Attached: Yes ☐ No ☒ N/A ☐  
 Receipt: Cash ☐ Cr ☒ Shipment Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection 11/14/14 N/A ☐  
 Work Order                      N/A ☒

### Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12                     

Production/Admin:                       
 Date: 11/4/13  
 Received/Costing:                       
 Initial:                     

Location

## Page 1 of 1

All amounts are calculated in domestic currency.

Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-COP001 Thyssenkrupp Materials CA Ltd									
PO13762	2		M606IT6T3.500W.3 f75	f	4/8/2011	4/13/2011	12.0000	\$12.62	0.0000	0	\$151.38
CAD	No		6061-T6 RD Tube 3.50 X .375 W 117392	f	12.0000	DESJ02		\$151.38	0.0000	0	
	6		M2024T3S.063	sf	4/8/2011	4/13/2011	288.0000	\$4.35	0.0000	0	\$1,251.88
	No		2024-T3 .063 sheet 117392	sf	288.0000	DESJ02		\$1,251.88	0.0000	0	
	7		M2024T3S.080	sf	4/8/2011	4/13/2011	96.0000	\$6.35	0.0000	0	\$609.99
	No		2024-T3 .080 sheet 117392	sf	96.0000	DESJ02		\$609.99	0.0000	0	
Total Received Quantity:											396.0000
Total Qty to Inspect (PO U/M):											0.0000
Total Reject Quantity:											0.0000
Total Receipt Value:											\$2,013.25
Total Balance Due Quantity:											0.0000

**B I L L O F L A D I N G**

No: PEC 705512

Ship From:  
 THYSSENKRUPP MATERIALS NA  
 2821 LANGSTAFF ROAD  
 CONCORD, ONTARIO L4K 5C6  
 Tel: 905 669 9444 Fax: 9057389033

Ship Date 08Apr11 at 14:44 From PFW  
 Probill  
 Via VIM TRANSFER TRUCK  
 FOB CONCORD  
 Frt PREPAID  
 Route 0- 0 Manifest  
 Vhcle Trailer  
 Slp STAN IVERS (905-532-1350)  
 Sold To: ( 20115)  
 DART AEROSPACE  
 1270 ABERDEEN ST  
 HAWKESBURY, ON K6A 1K7

2 Ship To: ( 1)  
 DART AEROSPACE  
 1270 ABERDEEN ST  
 HAWKESBURY, ON K6A 1K7  
 Tel: 613-632-9577 Fax: 613-632-1053

**B I L L O F L A D I N G**

1) Our Order PEC-317375- 1 Your PO # 13762  
 Part # 4-6 DAYS A.R.O Rel #  
 ALUMINUM SHEET 2024 -T3

.0640 Nom X 48.0000" X 144.0000"

Heat Number Tag No  
 175027 182717

Quantity PCS Wt LBS  
 288.00 SFT 6 261

2) Our Order PEC-317375- 2 Your PO # 13762  
 Part # 4-6 DAYS A.R.O Rel #  
 ALUMINUM SHEET 2024 -T3

.0810 Nom X 48.0000" X 144.0000"

Heat Number Tag No  
 201115 182242

Quantity PCS Wt LBS  
 96.00 SFT 2 111

3) Our Order PEC-317375- 3 Your PO # 13762  
 ALUMINUM TUBE 6061-T6511  
 3.50" OD x .375" WALL X 144.0000"  
 THIS ITEM IS BACK ORDERED

TOTAL: Tags 2 PCS 8 LBS 372

MILL TEST REPORTS, PACKING SLIPS ARE TO SENT  
 WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR  
 TO SHIPPING.

ATTN: CHANTAL/LINDA

\*\* ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER \*\*

\*\* REFERENCED ON IT \*\*

TOTAL 2 SKIDS G.W. 571 LBS

Page: 1 ....Continued

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ÊTRE

RAPPORTÉES IMMÉDIATEMENT.

ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY.

RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.

MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER.

REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION

DATE

TVQ/QST# 1017327981 TQ001 TPS/GST TVH/HST # 140223934 RT0001

Aleris Aluminum Koblenz GmbH  
Postfach 10 03 31 55033 Koblenz/Deutschland



Aleris  
Europe

INSPECTION CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0273620 SERIAL-NO.: ORDER NO. PURCH.: US-AIRCR-DEPOT-PROG/  
PURCHASER: ORDER NO. MAN.: 90413  
SPEC.: AMS4037+B209+QQ250/4  
CUSTOMER PART NO.:  
ITEM: 01 LOT: 201115 ALLOY/TEMPER: 2024 T3 PRODUCT: COIL  
QUANTITY: 145 DIMENSIONS: 0.080 x 48.00 x 144.00 INS

RESULTS:

Mechanical properties:

Pl. No.	Spec. No.	Y.S.	U.T.S.	El.
		KSI	KSI	%
Min. LT:		42,0	63,0	15,0
Max. LT:				
1 A		45,1	67,6	20,4
2 A		45,1	67,6	22,5
3 A		45,1	67,7	21,6
4 A		45,1	66,7	20,4
5 A		45,4	67,0	21,6

Chemical composition: in %, remainder Al

Cast No.: 4-06-5414

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	B
0,036	0,089	4,540	0,608	1,450	0,002	0,062	0,0235	0,0006
Zr	Pb	Ni	Sn	Be	Na	Li	V	H2 (*)
0,0019	0,0015	0,0059	0,0047	0,0000	0,0000	0,0000	0,0078	0,08
Al	Tl	Ti+Zr	Cu/Mg	Fe/Si				
		0,025	3,130					

(\*) = H2 in ml/100 g AL

Other tests:

Dimensional check: OK  
Surface control: OK

Normative references:

LEGIERUNGSNORM/CHEMICAL COMPOSITION STANDARD/COMPOSITION CHIMIQUE  
AMS 4037N+ASTM B 209-04+AMS-QQ-A-250/4A SEP1998  
FESTIGKEITSNORM/MECH. PROP. STANDARD/CARACTERISTIQUE MECANIQUE  
AMS 4037N+ASTM B 209-04+AMS-QQ-A-250/4A SEP1998  
BESTELLNORM/SPECIFICATION/NORME  
AMS 4037N+ASTM B 209-04+AMS-QQ-A-250/4A SEP1998

Charleston Aluminum LLC  
480 Frontage Rd.  
Gaston, SC 29053

WT-03-01/07



Aleris Aluminum Koblenz GmbH  
Postfach 10 03 31 56033 Koblenz/Deutschland



**Aleris**  
Europe

INSPECTION CERTIFICATE (EN 10206/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0273620

SERIAL-NO.:

PAGE: 2 / 03

PURCHASER:

ORDER NO. PURCH.: US-AIRCR.DEPOT-PROG/

ORDER NO. MAN.: 90613

SPEC.: AMS4037+B209+QQ250/4

CUSTOMER PART NO.:

ITEM: 01 LOT: 201115 ALLOY/TEMPER: 2024 T3

PRODUCT: COIL

QUANTITY: 145 DIMENSIONS: 0.080 x 48.00 x 144.00 INS

Band test:

L-direction

LT-direction OK

ST-direction

WT-TQ-OS 01/17

Charleston Aluminum LLC  
1480 Frontage Rd.  
Gastonia, SC 29053

Aleris Aluminum Koblenz GmbH  
Postfach 10 03 31 56033 Koblenz/Deutschland



*Aleris*  
Europe

INSPECTION CERTIFICATE (EN 10204/3.1) / TEST REPORT / APPROVED CERTIFICATE

NO.: 0273620

SERIAL-NO.:

PAGE: 3 / 03

PURCHASER:

ORDER NO. PURCH.: US-AIRCR.DEPOT-PROG/

ORDER NO. MAN.: 90413

SPEC.: AMS4037+B209+QQ250/4

CUSTOMER PART NO.:

Remarks:

CERTIFIED THAT THE WHOLE OF THE SUPPLIES DETAILED HEREBON HAVE BEEN  
INSPECTED, TESTED AND, UNLESS OTHERWISE STATED ABOVE, CONFORM IN ALL  
RESPECTS WITH THE REQUIREMENTS OF THE SPECIFICATION, CONTRACT OR ORDER.

Enclosures:

Charleston Aluminum LLC  
490 Frontage Rd  
Gaston, SC 29053

*P. Gardiner*  
Patrik Gardiner  
Quality assurance

Aleris Aluminum  
Koblenz GmbH

WT:00.05 017

Koblenz, the 01.03.07 SW



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO13762

Purchase Order Date 3/31/2011

PO Print Date 3/31/2011

Page Number 1 of 3

Order From :

VC-COP001

THYSSENKRUPP MATERIALS CA LTD  
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL "A"  
TORONTO, ON M5W 5V8  
CA

Contact Name

Vendor Phone 905 669 9444

Vendor Fax 905 738 9033

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAKED**  
(4/11/12)

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6A4.000W.250	6061T6 ANGLE 4.00 x 4.00 x .250	4/8/2011 Yes	✓ 20.00 f	Yours ppd	\$4.9450	\$98.90
		Special Inst:	MATERIAL: 6061-T6/T6510T6511 ALUMINUM ANGLE AS PER AMS-QQ-A-200/8				
2	M6061T6T3.500W.375 014	6061-T6 RD Tube 3.50 X .375 W	4/8/2011 Yes	1000 f	Yours ppd 4/11/12	\$12.6150	\$252.30
		Special Inst:	MATERIAL: 6061-T6 OR 6061-T62 TUBING PER SEAMLESS TUBING AS PER WW-T-700/6 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8				
3	M6061T6S.080	6061-T6 .080 Sheet	4/8/2011 Yes	✓ 336.00 sf	Yours ppd	\$3.4107	\$1,146.00

No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 3/31/2011



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
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## PURCHASE ORDER

Purchase Order ID PO13762

Purchase Order Date 3/31/2011

PO Print Date 3/31/2011

Page Number 2 of 3

Order From :

VC-COP001

THYSSENKRUPP MATERIALS CA LTD  
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL "A"  
TORONTO, ON M5W 5V8  
CA

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	905 669 9444	Requisition Nbr	
Vendor Fax	905 738 9033	Tax Resale Nbr	10127-2607
Vendor Account Nbr		Terms	Net 30
		Currency	CAD
		FOB	Destination-Collect

Special Inst: MATERIAL: 6061-T6/T62 ALUMINUM SHEET  
AS PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR  
AMS 4025 OR AMS 4027 OR ASTM B206

4	M6061T6S.063	6061-T6 .063 Sheet	4/8/2011	✓ 336.00	Yours ppd	\$2.6964	\$905.99
			Yes	sf			

Special Inst: MATERIAL: 6061-T6/T62 ALUMINUM SHEET  
AS PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR  
AMS 4025 OR AMS 4027 OR ASTM B206

5	M304S25GA	304/316 .020" Sheet	4/8/2011	✓ 32.00	Yours ppd	\$2.6810	\$85.79
			Yes	sf			

Special Inst: MATERIAL: AISI 304/316 SS SHEET  
ANNEALED 2B FINISH  
AS PER MIL-S-5059 OR AMS 5513 (304)  
OR AMS 5524 (316) OR ASTM A240 OR  
ASME SA240

6	M2024T3S.063	2024-T3 .063 sheet	4/8/2011	✓ 288.00	Yours ppd	\$4.3468	\$1,251.88
			Yes	sf			

Special Inst: MATERIAL: 2024-T3 ALUMINUM SHEET  
AS PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR  
AMS 4037 OR ASTM B209

No substitution or deviation without  
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Certificate of Conformity or Material  
Certification required when applicable

Change Nbr: 1

Change Date: 3/31/2011



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID **PO13762**

Purchase Order Date 3/31/2011

PO Print Date 3/31/2011

Page Number 3 of 3

Order From :

VC-COP001

THYSSENKRUPP MATERIALS CA LTD  
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"  
TORONTO, ON M5W 5V8  
CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

905 669 9444

905 738 9033

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

7 M2024T3S.080 2024-T3 .080 sheet 4/8/2011 96.00 Yours ppd \$6,354.1 \$609.99  
Yes sf

Special Inst: MATERIAL: 2024-T3 ALUMINUM SHEET  
AS PER QQ-A-250/4 OR AMS-QQ-A-250/4  
OR  
AMS 4037 OR ASTM B209

PO Total:

\$4,350.85

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY

Change Nbr: 1

Change Date: 3/31/2011

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consent.  
Certificate of Conformity or Material  
Certification required when applicable